

Date: Friday, 18/07/2008 1:11:02 PM
 User: Julie Lecocq

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: SEAT SUPPORT ASSEMBLY, RH
Job Number	: 40661		
Estimate Number	: 13329		
P.O. Number	:	Part Number	: D3784044
This Issue	: 18/07/2008 S.O. No. :	Drawing Number	: D3784 REV B
Prsht Rev.	: NC	Project Number	:
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 05008	Material	:
Written By	:	Due Date	: 06/08/2008 Qty: 2 Um: Each
Checked & Approved By	: <u>JLD 08.7.18</u>		
Comment	: Est Rev:A 08-05-19 new issue DD verified by:ec Est Rev:B 08-07-18 revB as per dwg DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

2.0	D3763044	End Fitting Assembly, RH
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
 End Fitting Assembly, RH
 batch: 40686

NO Qty's
 SAD 08/08/12

3.0	D37701	Tube
-----	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
 Tube
 batch: B40713

NO Qty's
 SAD 08/06/12

4.0	D37703	Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
 Tube
 batch: B40714

NO Qty's
 SAD 08/06/12

5.0	D3763041	End Fitting Assembly
-----	----------	----------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)
 End Fitting Assembly
 batch: 40684

NO Qty's
 SAD 08/06/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 18/07/2008 1:11:02 PM
User: Julie Lecocq

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: SEAT SUPPORT ASSEMBLY, RH

Job Number: 40661

Part Number: D3784044

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 MS21042L3 Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

batch:

M167665

AS 08/08/11 (R2)

7.0 AN960JD10L Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

batch:

M164885

(or NAS1149D0332J) batch:

AS 08/08/11 (R2)

8.0 AN52510R20 Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Screw

batch:

M168559

AS 08/08/11 (R2)

9.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-assemble as per dwg D3784

****Note 8: Hole "A" is located 5" from the end of D3770-3 tube and must be oriented down****

****Note 8: Hole "B" is located 5" from the end of D3770-1 tube and must be oriented forward****

SAD 08/08/12 (2)

10.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/12 (V2)

11.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # and batch # using a fine point permanent marker on inside of part and Stock

Location:

8/8/12

(20) SD

12.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2008/08/12

Job Completion



4 08-08-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

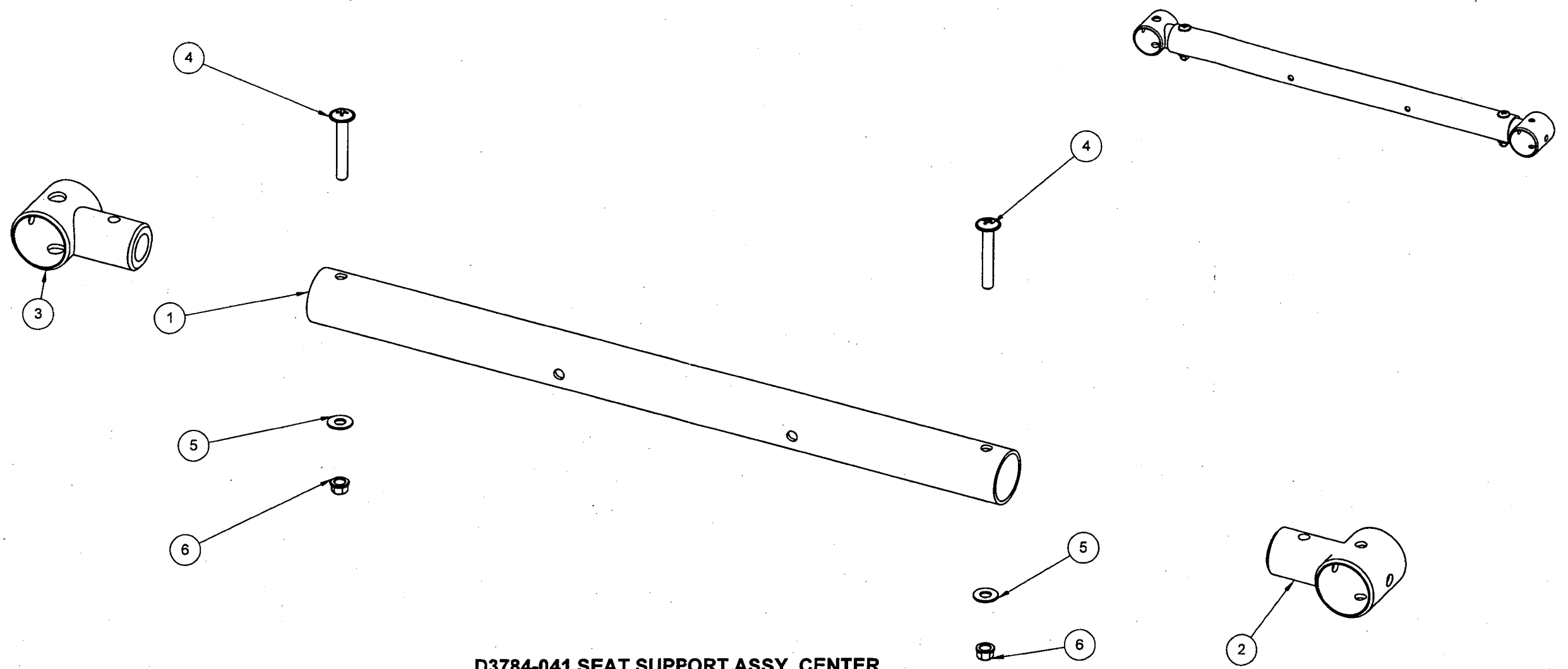
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D
C
B
A

D
C
B
A



D3784-041 SEAT SUPPORT ASSY, CENTER

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
1	D3770-1	TUBE	1
2	D3763-041	END FITTING ASSY	1
3	D3763-045	END FITTING ASSY	1
4	AN525-10R20	SCREW	2
5	NAS1149D0332J	WASHER (AN960JD10L)	2
6	MS21042L3	NUT	2

B
B
B
B

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

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WORK ORDER
NO. 4060

RELEASED
08.07.10

B	HARDWARE CHANGE, ASSY CHANGE	HS	08.06.23
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	HS	DRAWING NO.	REV. B
MFG. APPR.	HS	D3784	SHEET 1 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	HS	SEAT SUPPORT ASSEMBLY	NTS
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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

D

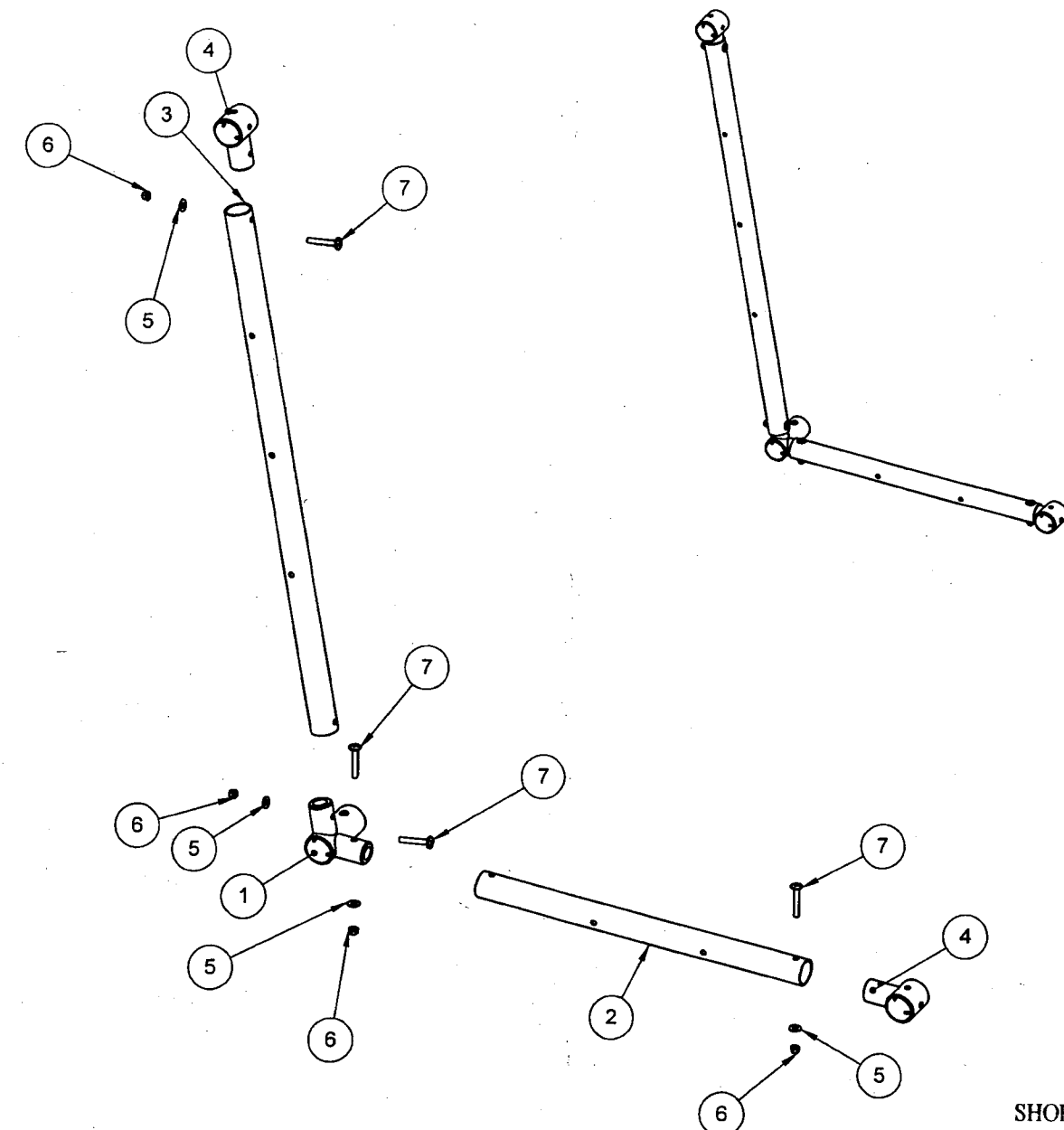
C

B

A

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-043)
1	D3763-043	END FITTING ASSY, LH	1
2	D3770-1	TUBE	1
3	D3770-3	TUBE	1
4	D3763-041	END FITTING ASSY	2
5	NAS1149D0332J	WASHER (AN960JD10L)	4
6	MS21042L3	NUT	4
7	AN525-10R20	SCREW	4

B
B
B



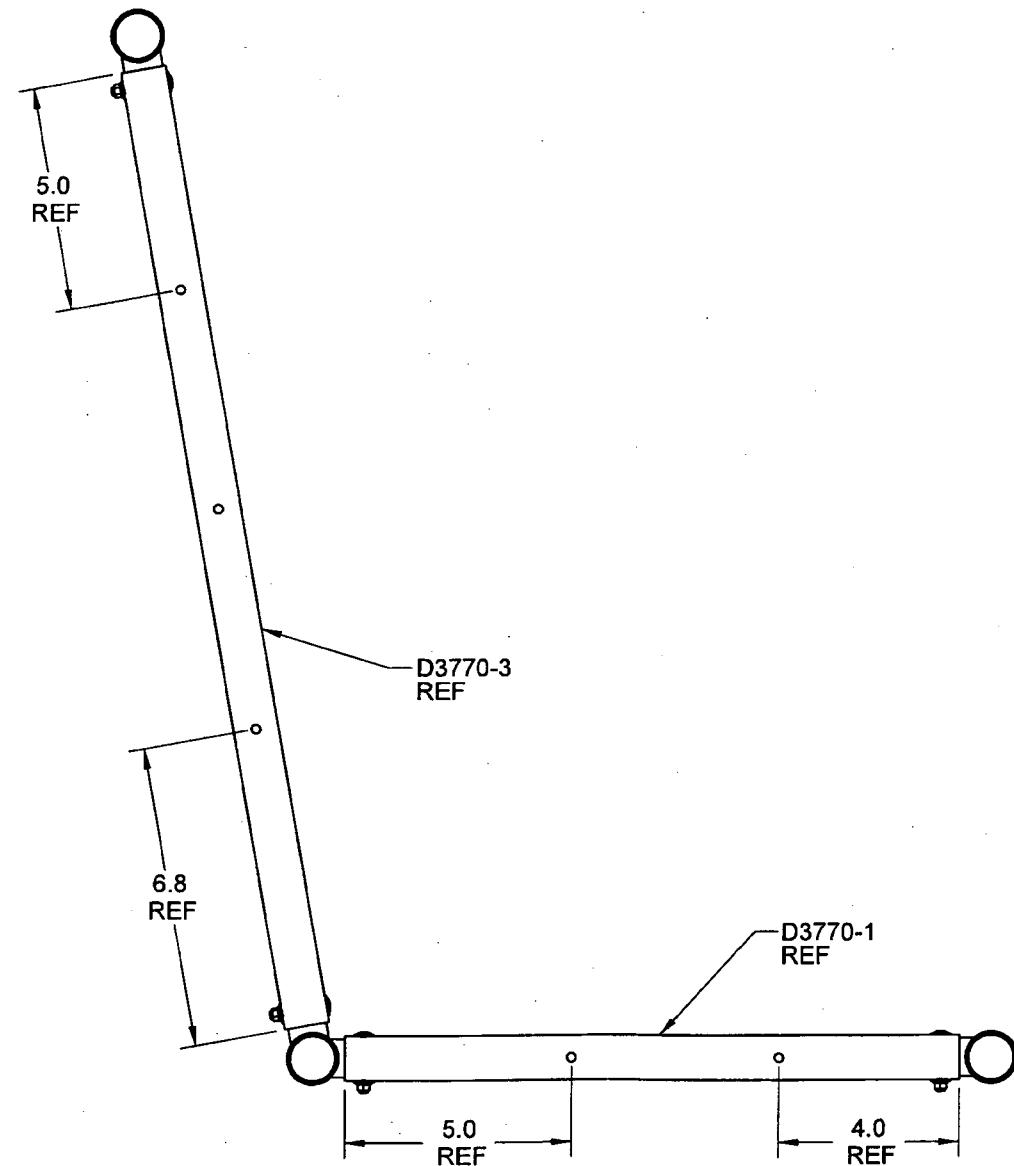
D3784-043 SEAT SUPPORT ASSY, LH

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.78 lbs

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MFG. APPR.	AD	D3784	SHEET 2 OF 5
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DE APPR.		SEAT SUPPORT ASSEMBLY	NTS
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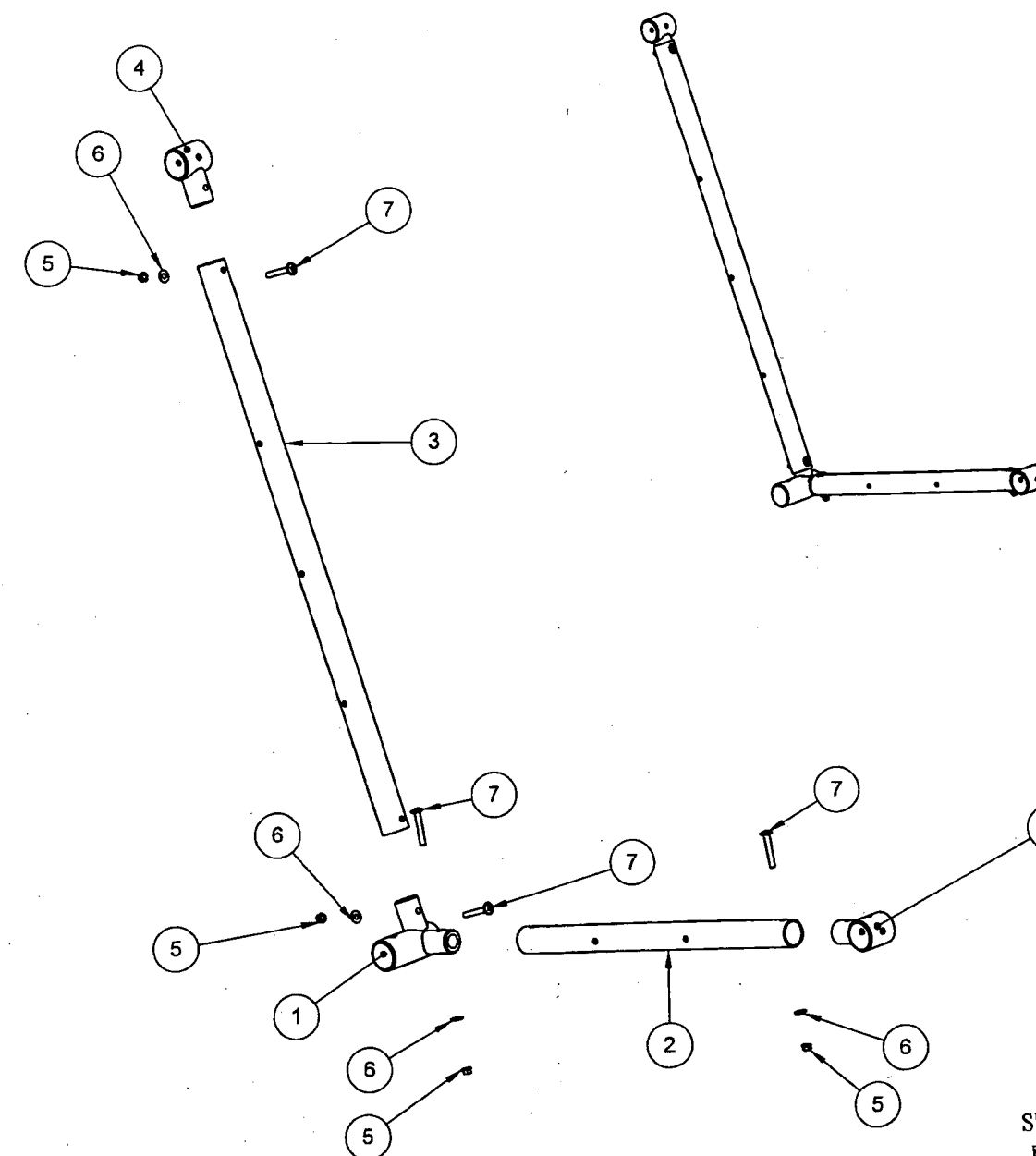


D3784-043 SEAT SUPPORT ASSY, LH

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MFG. APPR.	<i>[Signature]</i>	D3784	SHEET 3 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SEAT SUPPORT ASSEMBLY	NTS
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ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-044)
1	D3763-044	END FITTING ASSY, RH	1
2	D3770-1	TUBE	1
3	D3770-3	TUBE	1
4	D3763-041	END FITTING ASSY	2
5	MS21042L3	NUT	4
6	NAS1149D0332J	WASHER (AN960JD10L)	4
7	AN525-10R20	SCREW	4



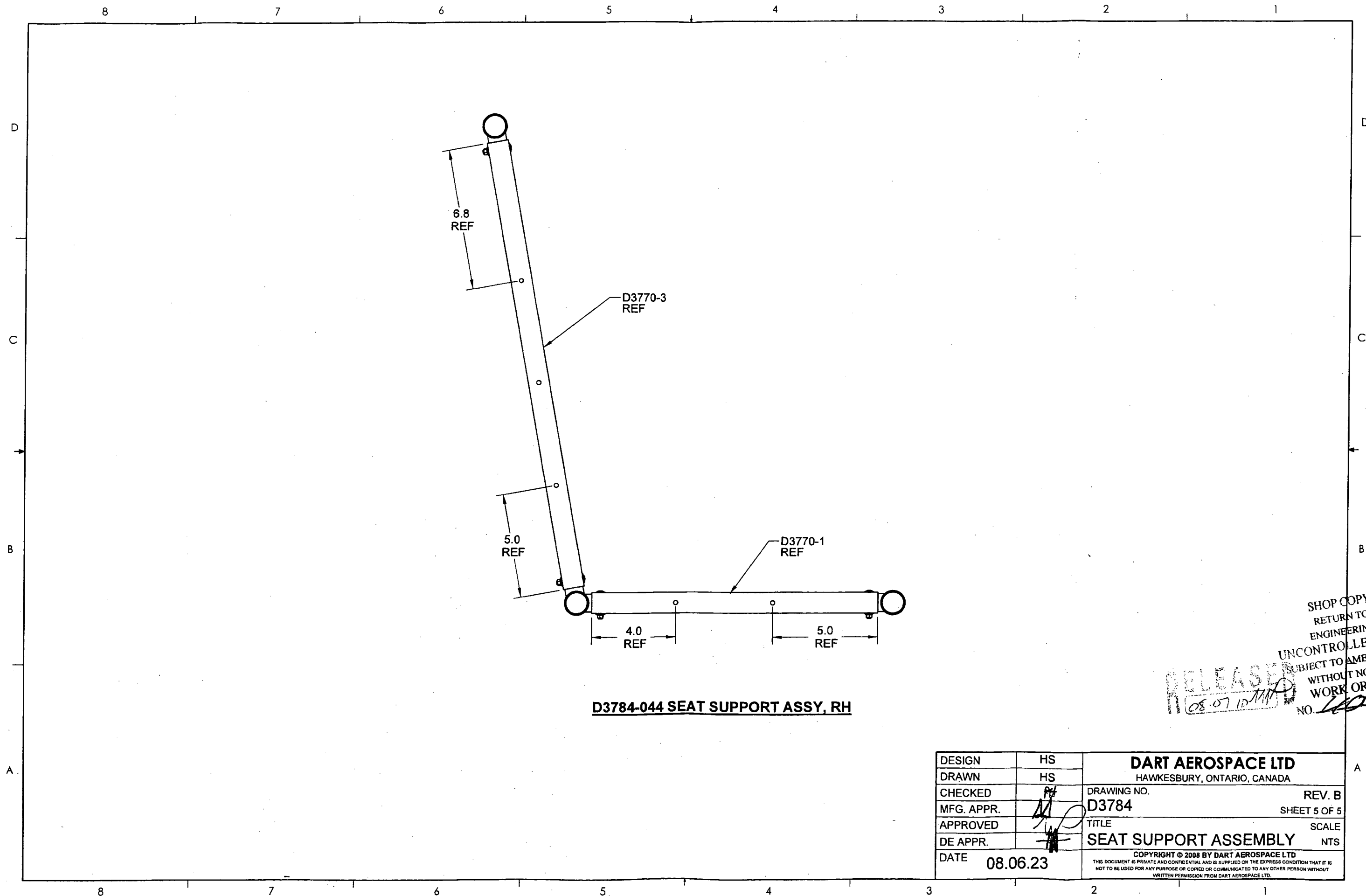
D3784-044 SEAT SUPPORT ASSY, RH

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.78 lbs

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
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MFG. APPR.	<i>[Signature]</i>	REV. B SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE SEAT SUPPORT ASSEMBLY
DE APPR.	<i>[Signature]</i>	SCALE NTS
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08-07-10

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DRAWN	HS		
CHECKED	<i>PH</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>PH</i>	D3784	SHEET 5 OF 5
APPROVED	<i>PH</i>	TITLE	SCALE
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